



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

May 7th
D5380-3

Job Sheet 176806



Part No: D5380-3

Job Qty: 6 ea

Part Name: Support Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/1/18

Job Tracking No:

Due Date: 5/14/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 3 IPP Rev: A New issue JFS 16/02/03 Verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		5/10/18	0.00	0.00	Start Up Machining-4		<i>mm</i>
100	CNC Vertical Machining	6 pcs		5/10/18	0.00	8.57	HAAS1-2		<i>V 18-05-10</i>
110	QC	6 pcs		5/10/18	0.00	0.00	QC2 Machining-4		<i>K 18-05-10</i>
120	QC	6 pcs		5/10/18	0.00	0.00	QC8 Machining-4		<i>2nd 18/05/13</i>
121	QC	6 pcs		5/10/18	0.00	0.00	QC5 <i>D14</i>		<i>38</i>
130	Packaging	6 pcs		5/10/18	0.00	0.00	Packaging3-2	<i>L6056</i>	<i>AA MAY 14 2018</i>
140	QC21-SA	6 Ea		5/10/18	0.00	0.00	QC21		<i>DAS 21 MAY 15 2018</i>

Part Op 100 - Machine as per Folio FB460
Descriptions: 130 - LOCATION : LG054

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-3TRN	Support Base Turnng Detail	3 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-3TRN	3	0	0
	<i>5069313</i>			

Part Specifications

Specifications could not be found.



Container No: S069794



Part: D5380-3

Job No: 176806

Serial No/Batch: S069794

Revision: C

Inspector:

1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
CANADA
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Plex 5/1/18 1:06 PM dart.lacelle.linda

Date: 05/09/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order: 170800
Description: Support Base		Part Number: D5380-3
Inspection Dwg: D5380	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	3.890	3.910		3.890	3.890	3.893	3.893	3.905
AB	0.256	0.263		0.257	0.257	0.257	0.257	0.257
AC	3.540	3.560		3.547	3.548	3.547	3.548	3.547
AD	1.765	1.785		1.772	1.778	1.768	1.769	1.7695
AE	0.590	0.610		0.600	0.600	0.606	0.600	0.600
AF	1.140	1.160		1.153	1.158	1.150	1.150	1.150
AG	2.290	2.310		2.301	2.300	2.300	2.300	2.300
AH	0.490	0.510		0.497	0.495	0.500	0.500	0.500
AI	0.115	0.135		0.124	0.122	0.125	0.125	0.125
AJ	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AK	0.140	0.160		0.150	0.155	0.1495	0.150	0.150
AL	1.502	1.522		1.520	1.520	1.514	1.519	1.519
AM	0.100	0.125		0.107	0.109	0.104	0.100	0.110
AN	0.053	0.073		R.063	R.062	0.0625	0.063	0.063
AO	0.220	0.280		R.250	R.250	0.250	0.250	0.250
AP	0.220	0.280		R.250	R.250	0.250	0.250	0.250
AQ	0.170	0.230		R.200	R.200	0.200	0.200	0.200
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by: M. M.	Date: 18/05/09
Audited by: G. M.	Date: 18/05/13
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

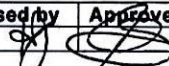
Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

DART AEROSPACE LTD		Work Order:	
Description: Support Base		Part Number:	D5380-3
Inspection Dwg: D5380 Rev: B		Page 1 of 1	

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AM	0.100	0.125		0.063				
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AO	0.220	0.280		0.250				
AP	0.220	0.280		0.250				
AQ	0.170	0.230		0.200				
AR								
AS								
AT								
AU								
AV								
AW								
AX								
AY								
AZ								
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:	KJ	Date:	18/05/10
Audited by:	Tnx	Date:	18/05/13
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	

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